

Date: Thursday, 8/30/2007 3:49:44 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ASSEMBLY
Job Number	: 34351		
Estimate Number	: 10464		
P.O. Number	: <i>NIA</i>	Part Number	: D3278041
This Issue	: 8/30/2007	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D3278 UNDER REVIEW <i>Rev C. E</i>
First Issue	: <i>NIA</i>	Project Number	: N/A
Previous Run	: 34006	Drawing Revision	: <i>SC E</i>
		Material	: <i>NIA</i>
Written By	: _____	Due Date	: 9/21/2007
Checked & Approved By	: _____	Qty:	20 Um: Each
Comment	: Est:A 04.04.19 Newissue KJ/JLM EST B 07.08.21 Chg rivet per PAR185 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	34351A	SUPPORT
-----	--------	---------



Comment: Sub-Component SUPPORT

D3278-1 B *34351A*

*mf*

2.0	34351B	SUPPORT
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Comment: Sub-Component SUPPORT

D3278-2 B *34517B x 9mx, B34351B x 11mx.*

*mf*

3.0	D32783	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	<i>B34525</i>

*mf*

4.0	MS20426AD36	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
4	MS20426AD3-6	Rivet	<i>m105055</i>

*mf 07-10-10.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:44 PM  
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 34351

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

mf 07-10-10 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07/10/10 20

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

133250

mf

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

m105426

mf

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

m104746

mf

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

m104683

mf 07-10-10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: PD Date: 21/10/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 8/30/2007 3:49:44 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 34351

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

\*\*\*DO NOT TIGHTEN BOLTS\*\*\*

Identify as D3278-041

MF 07-10-10 (20)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count 07/10/10 (20)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/10/10 (20)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/11 (20)

Job Completion



U 07-10-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

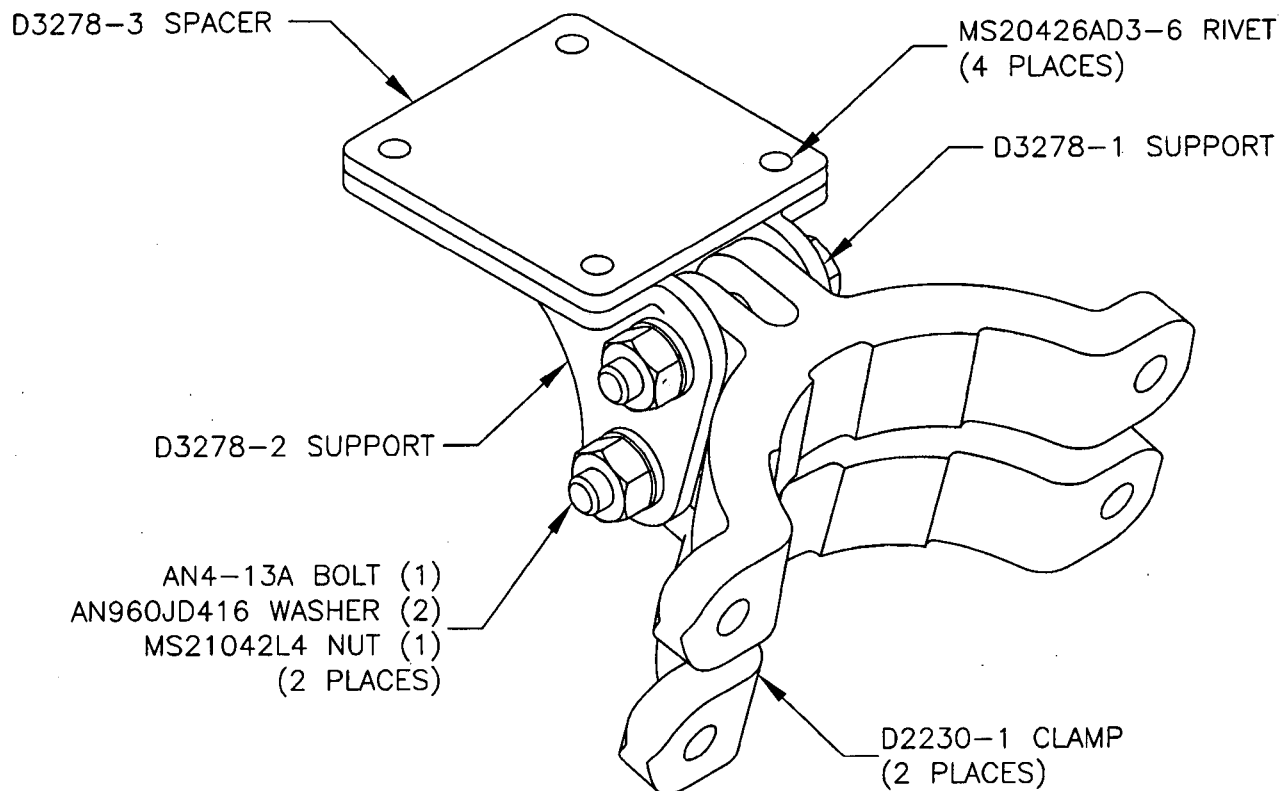
NOTE: Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07 08 06

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

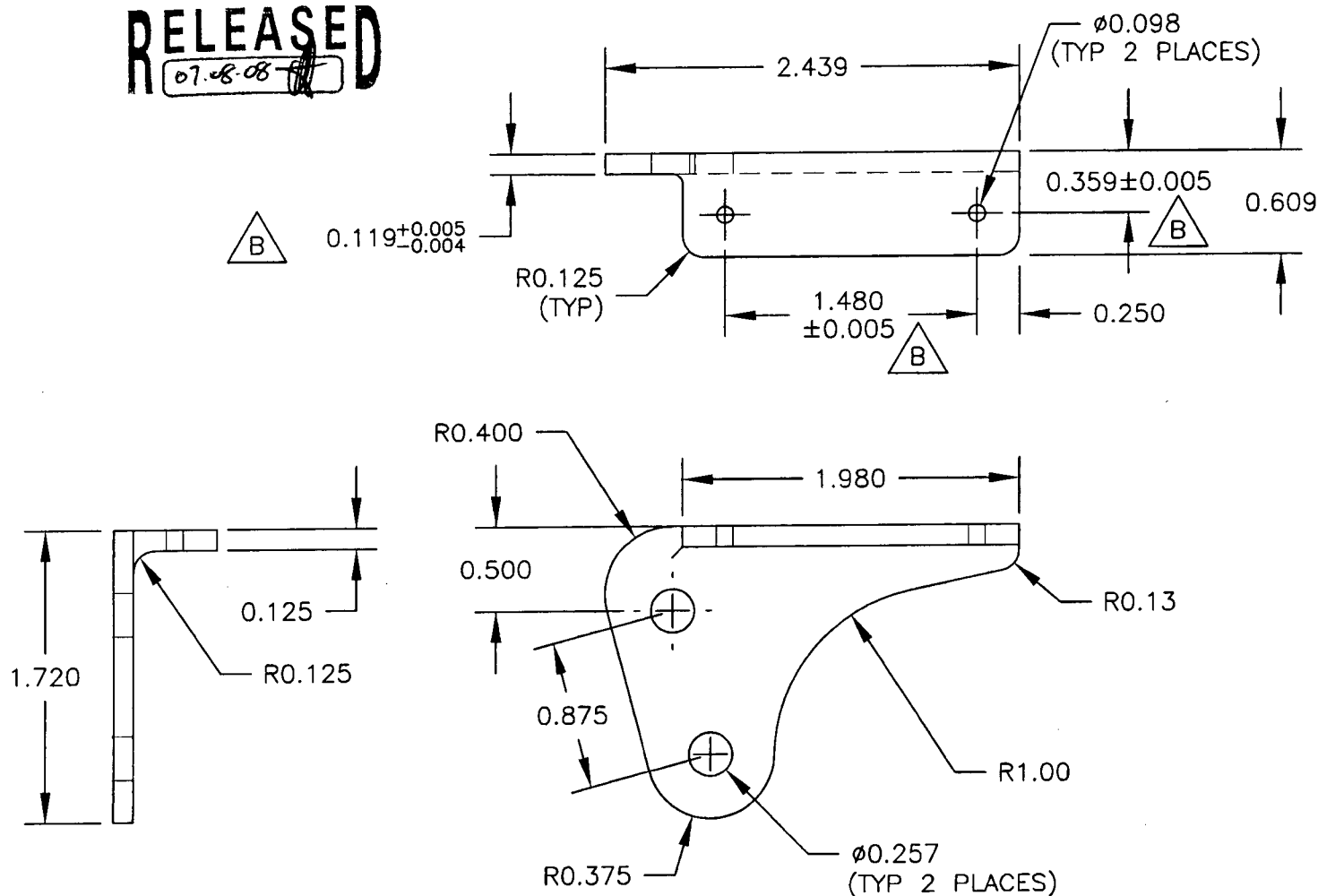
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**DART**

DESIGN 901	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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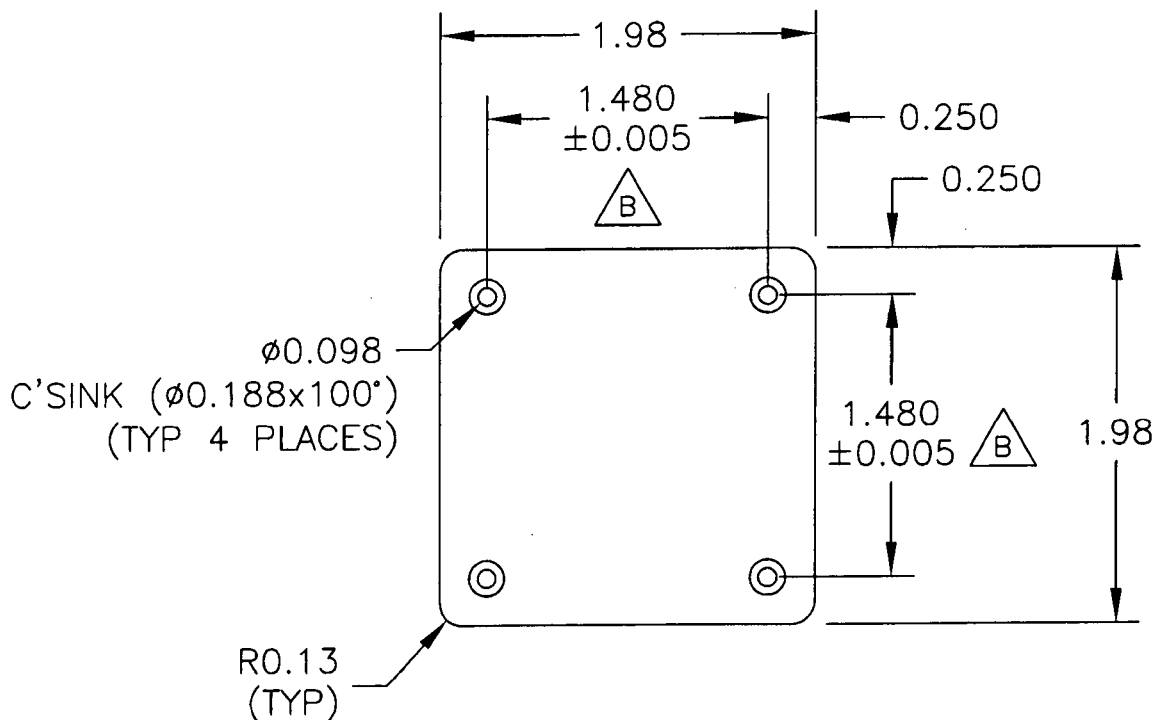
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**DART**

DESIGN 9P1	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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